

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003438**Date Inspected:** 01-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wen Pang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe fabrication and perform Ultrasonic Testing (UT) of Orthotropic Box Girder (OBG) components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Sub Assembly Shop Bay # 7

The Caltrans QA Inspector performed UT verification of ZPMC Quality Control (QC) inspected and accepted Floor beam Complete Joint penetration welds, FB014-008-043 & 044, FB014-011-043, FB014-008-043 & 044, FB014-007-043 & 044, FB013-011-043 & 044, FB013-006-044, FB028-002-126 (R2) and FB028-002-127 (R2). The welds tested appeared to be in general conformance with AWS D1.5 table 6.3 and contract documents. See UT report TL-6027 generated on this date for further information.

OBG Assembly Shop Bay # 2

The Caltrans QA Inspector performed 10% verification Magnetic particle Testing (MT) on the following fillet welds joining T-stiffeners to side and bottom panels on OBG section 4BW: SP-038-001 and SP062-001. All of the welds that were examined appeared to comply with AWS D1.5 2002 and the contract documents. See MT report TL-6028 generated on this date for further information.

Summary of Conversations:

Only general conversations between Caltrans QA and QC occurred this date.

WELDING INSPECTION REPORT

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco, 138 1694 2685, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
